

# Work Order ID 86225

**\*86225\***

Page 1

June-25-12 10:28:52 AM

Item ID: D135-751-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube Installation

Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/12 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3492

C

D3507

Rev C

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D135-751-011 CHG001

DAS  
16

12/07/04

MLJ 12-8-30

**B86225**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86225

June-25-12 10:28:52 AM

**\*86225\***

Page 2

Item ID: D135-751-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Skidtube Installation

Stop

**\*NS2\***

Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

0.00

**\*120\***

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Cut Aft end as per dwg D3507

*BE 12/08/03*

2-Deburr ends

*BE 12/08/03*

3-Drill Aft & Fwd Cap holes using DT8678 & DT8901

*BE 12/08/03*

4-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill. \*\*\*\*DO NOT OPEN AFT CAP HOLES\*\*\*\*

7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868,Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open six rear wearplate holes using DT8892.Open holes to 0.297"

*BE 12/08/20*

9-Open Aft & Fwd Cap holes using .208" drill.

10-Bore out aft end of tube as per Dwg D3507 & Detail "B".

11-Open ground wire hole .297" section E-E

12- Section G-G holes must be laid out manually, open to #30.

*BE 12/08/20*

13-Deburr holes.

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Work Order ID 86225

**\*86225\***

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June-25-12 10:28:52 AM

Item ID: D135-751-011

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube Installation

Stop **\*NS2\***

Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							
150 <b>*150*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00							
160 <b>*160*</b> QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00  0.00							

DAS  
16  
9-89

12/08/21

1 76 128.21

1 38 12/08/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

# Work Order ID 86225

**\*86225\***

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June-25-12 10:28:52 AM

Item ID: D135-751-011

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**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube Installation

Stop **\*NS2\***

Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

0:00

**\*170\***

Skidtubes

Skidtubes

Memo

0.00

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507 and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex Batch: M122443  
Exp Date: 14/03/13  
start time: 2:45  
end time: 12/08/23

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD Batch: m122324 12/08/23

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

8-Deburr Rivet holes.

*Handwritten notes and signatures:*  
12/08/22  
12/08/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D135-751-011

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**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Skidtube Installation

Stop

**\*NS2\***

Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC10- Inspect visual per QS1004- ground welds

0.00

**\*180\***

QC

Memo

0.00

Quality Control

190

Skidtubes

0.00

**\*190\***

Skidtubes

Memo

0.00

Skidtubes

1-Rivet D3506-1/-3 as per Dwg D3507.

200

QC5- Inspect part completeness to step on W/O

0.00

**\*200\***

QC

Memo

0.00

Quality Control

DAS  
16  
2-83 11/6/27

CF 12.8.27

DAS  
16  
2-83 11/28/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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# Work Order ID 86225

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June-25-12 10:28:52 AM

Item ID: D135-751-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Skidtube Installation

Stop

**\*NS2\***

Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

Pressure Wash per QSI005 4.3

0.00

**\*210\***

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 26 12-8-28

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*220\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:10  
320°F  
9:40

IX 12/08/28

230

QC3- Inspect Part Finish

0.00

**\*230\***

QC

Memo

0.00

Quality Control

1 4 11/08/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 86225

June-25-12 10:28:52 AM

**\*86225\***

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Item ID: D135-751-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube Installation

Stop **\*NS2\***

Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	HandFinishing	0.00							
<b>*260*</b>	HandFinish								
Hand Finishing	Memo	0.00							
<div> <div>✓ 1- Install Wearplate &amp; Ground Wire inserts as per Dwg D3507.</div> <div>✓ 1- Inspect for Foreign objects</div> <div>✓ 2- Install Fwd &amp; Aft caps as per Dwg D3507 And Detail "A" &amp; "B"</div> <div>A/R 241 Sika Flex Batch: <u>AA122413</u></div> <div>Exp Date: <u>13/03</u></div> <div>✓ 3- Install Wearplates as per Dwg D3507,</div> <div>Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube</div> <div>Do not Install Screws where indicated on Dwg (Note #6)</div> <div>✓ A/R 241 Sika Flex Batch: <u>AA122413</u></div> <div>Exp Date: <u>13/03</u></div> <div>✓ 4- assemble o'ring to plug as per dwg D3492 and apply o'ring lube</div> <div>A/R 55-o'ring lube batch: <u>AA121661</u></div> <div>✓ 5- Wing Walk as per Dwg D3507 and QSI 005 4.4</div> <div>Batch: <u>AA122320</u></div> </div>									

1x 4 Ill 4/08/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Work Order ID 86225

**\*86225\***

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June-25-12 10:28:52 AM

Item ID: D135-751-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Skidtube Installation

Stop

**\*NS2\***

Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

270

QC5- Inspect part completeness to step on W/O

0.00

**\*270\***

QC

Memo

0.00

Quality Control

280

Pick Kit

0.00

**\*280\***

Packaging

Memo

0.00

Packaging

290

QC4- 100% Inspect kits for completeness

0.00

**\*290\***

QC

Memo

0.00

Quality Control

SMB  
12-8-30  
DAS 16  
17/06/32

DAS 16  
26/09/04

1x  
SD  
12-8-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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June-25-12 10:28:52 AM

**\*86225\***

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Item ID: D135-751-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube Installation

Stop **\*NS2\***

Start Date: 25/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	Packaging	0.00							
<b>*300*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D135-751-011								
	Location: _____								
	PPP Rev: <u>B</u>								
310	QC21- Final Inspection - Work Order Release	0.00							
<b>*310*</b>									
QC	Memo	0.00							
Quality Control									

*K*

*Sp*

*12-9-4.*

*12/9/5*

*ME*

*12-09-04*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

June-25-12 10:28:55 AM

Page 1

Work Order ID: 86225

**\*86225\***

Parent Item: D135-751-011

**\*D135-751-011\***

Parent Item Name: Skidtube Installation

Start Date: 25/06/2012

Required Date: 05/07/2012

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:A06-06-21New Issue JLM  
 IPP Rev:B 06-12-18 As per Rev B JLM  
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD  
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC vcerified DD  
 IPP Rev E 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F  
 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17  
 added D3507-1-bent EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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ALS7-1032-130

Purchased

No

Each

1,998.000

38

**\*AI S7-1032-130\***

\*\*

nl 08/28

Insert

### Location

### Loc Qty

### Loc Code

ST280

51

1122474 x38

117717

27

118966

22

119775

2

ST282

1947

119530

73

120181

12

121444

1862

D3507-1-BENT

Manufactured

No

120

Each

4.0000

1

1

**\*D3507-1-BFNT\***

\*\*

Skidtube Assembly EC135

### Location

### Loc Qty

### Loc Code

LG

4

77441

1

83177

2

83303

1

BE 12/08/03  
 B88713

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 86225

**\*86225\***

Parent Item: D135-751-011

**\*D135-751-011\***

Parent Item Name: Skidtube Installation

Start Date: 25/06/2012

Required Date: 05/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3504-1 Manufactured No

170 Each 24.0000 2 2

**\*D3504-1\***

Crossbolt Spacer

\*\*

*BE 12/08/23*

Location	Loc Qty	Loc Code
LG	3	
82725	3	
LG001	21	
53742	2	
75240	19	

*2*

D3504-3 Manufactured No

170 Each 24.0000 1 1

**\*D3504-3\***

Crossbolt Spacer

\*\*

*BE 12/08/23*

Location	Loc Qty	Loc Code
LG	13	
82726	13	
LG001	11	
53743	11	

*1*

D3504-5 Manufactured No

170 Each 17.0000 2 2

**\*D3504-5\***

Crossbolt Spacer

\*\*

*BE 12/08/23*

Location	Loc Qty	Loc Code
LG001	17	
76239	5	
82727	12	

*1*

*1*

D3505-1 Manufactured No

170 Each 2.0000 1 1

**\*D3505-1\***

Web

\*\*

*DE 12/08/22*

Location	Loc Qty	Loc Code
LG001	2	
75211	1	
83547	1	

*①*

June-25-12 10:28:55 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 3

Work Order ID: 86225

**\*86225\***

Parent Item: D135-751-011

**\*D135-751-011\***

Parent Item Name: Skidtube Installation

Start Date: 25/06/2012

Required Date: 05/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3506-1 Manufactured No

190 Each 23.0000 4 4

**\*D3506-1\***

Doubler

\*\*

~~SP~~ CF 12-8-29

Location

Loc Qty

Loc Code

ST051

23

75090

23

D3506-3 Manufactured No

190 Each 47.0000 2

**\*D3506-3\***

Doubler

\*\*

~~2~~ CF 12-8-29

Location

Loc Qty

Loc Code

ST051

47

51790

47

MS20601-AD4W3 Purchased No

190 Each 1,767.000 12 12

**\*MS20601-AD4W3\***

Rivet

\*\*

~~SP~~ CF 12-8-24

Location

Loc Qty

Loc Code

ST321

1767

114538

1767

ALS4-1032-225 Purchased No

260 Each 493.0000 1

**\*ALS4-1032-225\***

Insert

\*\*

~~12~~ 11/08/28

Location

Loc Qty

Loc Code

ST281

470

108696

146

110768

62

118386

55

118966

68

121269

139

ST282

23

120410

10

120451

13

M 122290

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 4

Work Order ID: 86225

\*86225\*

Parent Item: D135-751-011

\*D135-751-011\*

Parent Item Name: Skidtube Installation

Start Date: 25/06/2012

Required Date: 05/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

260

Each

4,859.000

31

31

**\*AN3C4A\***

BOLT

\*\*

yl 12/08/28

Location

Loc Qty

Loc Code

ST350 -

4859

120187

31

120521

28

120769

38

121205

754

121556

8

122151

4000

Y31

AN3C5A

Purchased

No

260

Each

1,688.000

2

2

**\*AN3C5A\***

Bolt

\*\*

yl 12/08/28

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1681

116419

28

117343

13

117764

7

117872

2

119749

23

120423

28

121068

12

121255

500

121444

68

121708

500

122141

500

Y2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Page 5

Work Order ID: 86225

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

\*86225\*

\*D135-751-011\*

Start Date: 25/06/2012

Required Date: 05/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN526C1032R10

Purchased

No

260

Each

189.0000

2

\*\*

2  
JL 12/08/28

\*AN526C1032R10\*

Screw

Location

Loc Qty

Loc Code

FP002

69

108062

69

V2

ST348

120

110049

20

114494

100

AN960C10L

NAS1149C0332

Purchased

No

260

Each

21.0000

33

33

\*AN960C10L \* \*

washer

M122063 \*\*

(x33) JL 12/08/28

Location

Loc Qty

Loc Code

ST

21

107534

21

D2965

Manufactured

No

260

Each

44.0000

1

1

\*D2965\*

Cap, 105 Skidtube

\*\*

JL 12/08/28

Location

Loc Qty

Loc Code

FP002

44

71371

4

80089

40

V1

D2965-3

Manufactured

No

260

Each

11.0000

1

1

\*D2965-3\*

Cap

\*\*

JL 12/08/28

Location

Loc Qty

Loc Code

FP002

11

50560

1

75254

3

84051

7

X1

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 86225

**\*86225\***

Parent Item: D135-751-011

**\*D135-751-011\***

Parent Item Name: Skidtube Installation

Start Date: 25/06/2012

Required Date: 05/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3492-1 Manufactured No

260

Each

205.0000

4

4

**\*D3492-1\***

Plug

\*\*

HL 11/08/28

Location

Loc Qty

Loc Code

FP002

198

B87662

XL

69531

8

74444

2

76235

4

83259

184

FP-A

7

83098

7

D3492-3 Manufactured No

260

Each

139.0000

4

4

**\*D3492-3\***

Plug

\*\*

HL 11/08/28

Location

Loc Qty

Loc Code

FP-A

139

B85461

XL

81967

5

83099

12

83529

122

D3492-7 Manufactured No

260

Each

22.0000

2

2

**\*D3492-7\***

Plug

\*\*

HL 11/08/28

Location

Loc Qty

Loc Code

FP002

22

71881

2

77222

20

XL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 7

Work Order ID: 86225

**\*86225\***

Parent Item: D135-751-011

**\*D135-751-011\***

Parent Item Name: Skidtube Installation

Start Date: 25/06/2012

Required Date: 05/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3508-1 Manufactured No

260

Each

6.0000

1

1

**\*D3508-1\***

Wearplate

\*\*

HL 12/08/28

Location

Loc Qty

Loc Code

FP

6

85407

6

V1

D3508-3 Manufactured No

260

Each

7.0000

1

1

**\*D3508-3\***

Wearplate

\*\*

HL 12/08/28

Location

Loc Qty

Loc Code

FP001

7

38527

1

81347

6

V1

D3508-5 Manufactured No

260

Each

10.0000

1

1

**\*D3508-5\***

Wearplate

\*\*

HL 12/08/28

Location

Loc Qty

Loc Code

FP001

10

71688

2

72416

8

V1

D3508-7 Manufactured No

260

Each

7.0000

1

1

**\*D3508-7\***

Wearplate

\*\*

HL 12/08/29

Location

Loc Qty

Loc Code

FP001

7

76265

7

B88207

V1

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 86225

**\*86225\***

Parent Item: D135-751-011

**\*D135-751-011\***

Parent Item Name: Skidtube Installation

Start Date: 25/06/2012

Required Date: 05/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3558-1

Manufactured No

260 Each

37.0000

1

1

**\*D3558-1\***

Gasket

\*\*

HL 12/08/28

Location

Loc Qty

Loc Code

FP002

37

50925

1

73561

3

84090

33

xl

D3558-3

Manufactured No

260 Each

7.0000

1

1

**\*D3558-3\***

Gasket

\*\*

HL 12/08/28

Location

Loc Qty

Loc Code

FP

6

82312

6

FP002

1

71651

1

xl

D3558-5

Manufactured No

260 Each

6.0000

1

1

**\*D3558-5\***

Gasket

\*\*

HL 12/08/28

Location

Loc Qty

Loc Code

FP002

6

75255

6

xl

D3558-7

Manufactured No

260 Each

4.0000

1

1

**\*D3558-7\***

Gasket

\*\*

HL 12/08/28

Location

Loc Qty

Loc Code

FP002

4

75249

4

B386037

xl

June-25-12 10:28:56 AM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

# Picklist Print

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Page 9

Work Order ID: 86225

**\*86225\***

Parent Item: D135-751-011

**\*D135-751-011\***

Parent Item Name: Skidtube Installation

Start Date: 25/06/2012

Required Date: 05/07/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-007

Purchased

No

260

Each

254.0000

2

2

**\*NAS1611-007\***

O-RING

\*\*

*HL 12/08/25*

Location

Loc Qty

Loc Code

FP001

254

103697

254

NAS1611-010

Purchased

No

260

Each

416.0000

4

4

**\*NAS1611-010\***

O-RING

\*\*

*HL 12/08/25*

Location

Loc Qty

Loc Code

FP001

416

110915

14

117460

8

118077

1

118612

3

119438

47

121259

2

121584

2

121723

39

122151

300

NAS1611-013

Purchased

No

260

Each

317.0000

4

4

**\*NAS1611-013\***

O-RING

\*\*

*HL 12/08/25*

Location

Loc Qty

Loc Code

FP001

317

116582

5

117291

2

117887

53

119623

36

121584

5

121825

174

121826

42

*X4*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June-25-12 10:28:56 AM

Work Order ID: 86225

\*86225\*

Parent Item: D135-751-011

\*D135-751-011\*

Parent Item Name: Skidtube Installation

Start Date: 25/06/2012

Required Date: 05/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No

280 Each 4,859.000 8 8

\*AN3C4A\*

BOLT

\*\*

m122814 sp. l

Location

Loc Qty

Loc Code

ST350

4859

120187

31

120521

28

120769

38

121205

754

121556

8

122151

4000

AN960C10L NAS1149C0332 Purchased No

280 Each 21.0000 8 8

\*AN960C10I \*

washer

\*\*

m122063 sp l

Location

Loc Qty

Loc Code

ST

21

107534

21

D3512-1 Manufactured No

280 Each 21.0000 2 2

\*D3512-1\*

Wearplate

\*\*

sp 12-8-31

Location

Loc Qty

Loc Code

ST500

1

74735

1

ST501

20

81352

2

83343

18

ax

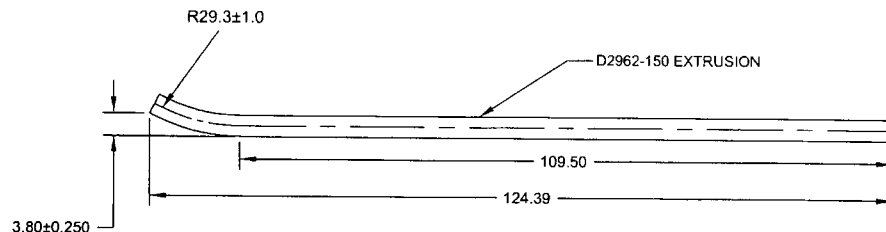
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

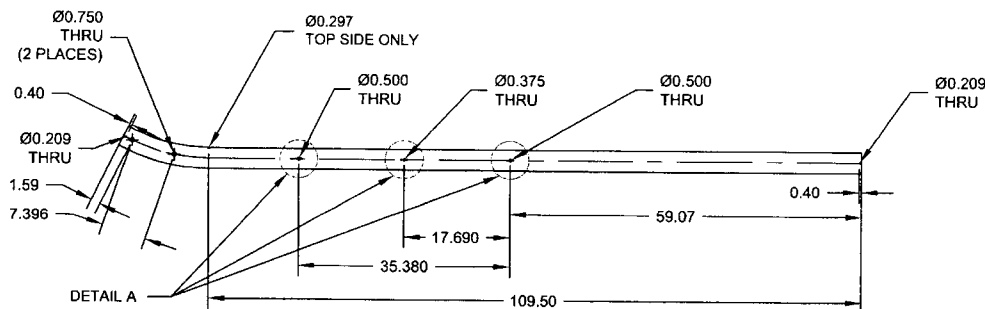
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

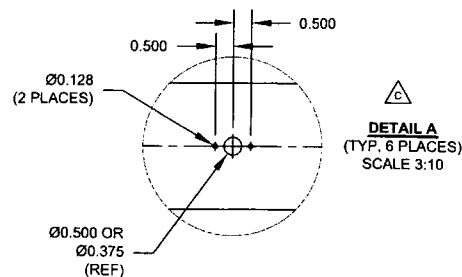
**NOTE:** Date & initial all entries



**D3507-1 BENDING/CUTTING DETAIL**



**D3507-1 DRILLING DETAIL**



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. EL0225 MLJ  
12/06/25

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

**GENERAL NOTES:**

- 1) FINISH:  
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	JTC		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.09.19		

<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWING NO. D3507	REV. C SHEET 1 OF 2
TITLE EC 135 SKIDTUBE	SCALE NTS
COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED  
07.11.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

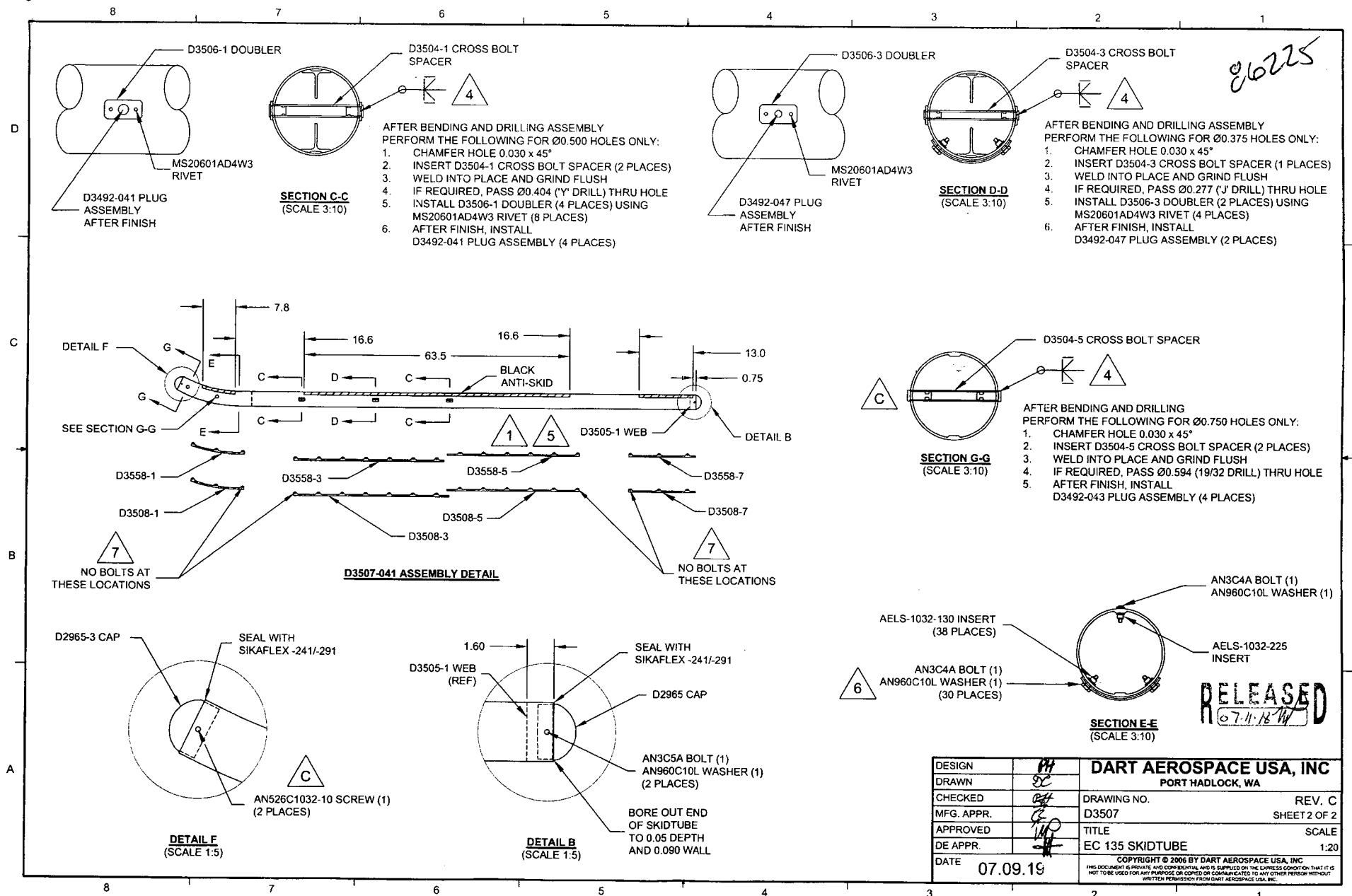
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 247

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 66661  
Part number: D135-751-011  
Description: 135 SKID TUB  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Pat Lewis Date of Test Coupon 11/03/17  
Welder Barclay Elliot Date of Test Coupon 11/03/17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld